

# Work Order ID 64548

Wednesday, December 08, 2010 10:11:44 A

Page 1

Item ID: D3315-1

Accept

Setup Start

Revision 1:

Stop

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 7.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet  
1010.063

1-Cut as per Dwg D3315 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

B10-12-22

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B10-12-22

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

81012/23

7

**Work Order ID 64548**

Wednesday, December 08, 2010 10:11:44 A

Page 2

Item ID: D3315-1

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Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 7.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

N/A S

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B 2- Form using  
DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: B

SD 10/01/03 (7)

150

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

S n b i / 03

(7)

1

# Work Order ID 64548

Wednesday, December 08, 2010 10:11:44 A

Page 3

Item ID: D3315-1

Accept

Setup Start

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Stop

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 7.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:

☒ Qty Part Number Description Batch ☐ A/R  
N/A 7560 Hardcoat Rod M115552

EL 14-1-5 (X7)

170

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Sulobos

180

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Sulobos

(X7)

-1

# Work Order ID 64548

Wednesday, December 08, 2010 10:11:44 A



Page 4

Item ID:	D3315-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate					
Start Date:	12/8/2010	Start Qty: 7.00		Cust Item ID:		
Required Date:	12/22/2010	Req'd Qty: 7.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>10:20</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:50</i>	0.00 0.00				<i>7</i>	<i>11-01-6</i>		
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>=7 ML</i>	<i>11/01/06</i>		<i>7</i>	<i>Ø</i>		
210  Packaging Packaging Packaging	Packaging  Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-1, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>495</i>	0.00 0.00					<i>11/1/6</i>	<i>70P</i>	

**Work Order ID 64548**

Page 5

Wednesday, December 08, 2010 10:11:44 A

Item ID: D3315-1

Accept



Setup Start



Revisor ID:

Stop



Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/07

MF

11-01-06

# Picklist Print

Wednesday, December 08, 2010 10:11:49 AM

Page 1

Work Order ID: 64548

Parent Item: D3315-1

Parent Item Name: Weir plate




Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP: A 05.05.12 New issue KJ/JLM  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	84.5250	1.695	12.35938			



12-10-22

Location

Loc Qty

Loc Code

MAT19

84.525

111410

84.525

111410

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	6415418
Description: Wearplate		Part Number:	D3315-1
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	267X450	X	X	V HB02	
4.402	+/-0.010	4.400	X		V	
4.137	+/-0.010	4.137	X		V	
3.550	+/-0.010	3.557	X		V	
5.464	+/-0.010	5.466	X		V	
5.214	+/-0.010	5.215	X		V	
1.224	+/-0.010	1.224	X		V	
2.57	+/-0.030	2.566	X		V	
6.273	+/-0.010	6.266	X		V	
8.224	+/-0.010	8.224	X		T HB01	
9.515	+/-0.010	9.515	X		T	
11.429	+/-0.010	11.429	X		T	
15.474	+/-0.010	15.474	X		T	
16.379	+/-0.010	16.379	X		T	
21.360	+/-0.010	21.360	X		T	
23.474	+/-0.010	23.474	X		T	
26.273	+/-0.010	26.273	X		T	
29.42	+/-0.030	29.42	X		T	
0.060	+/-0.010	.057	X		V	
Ø0.300	+0.006/-0.001	.300	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-22	Date: 10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

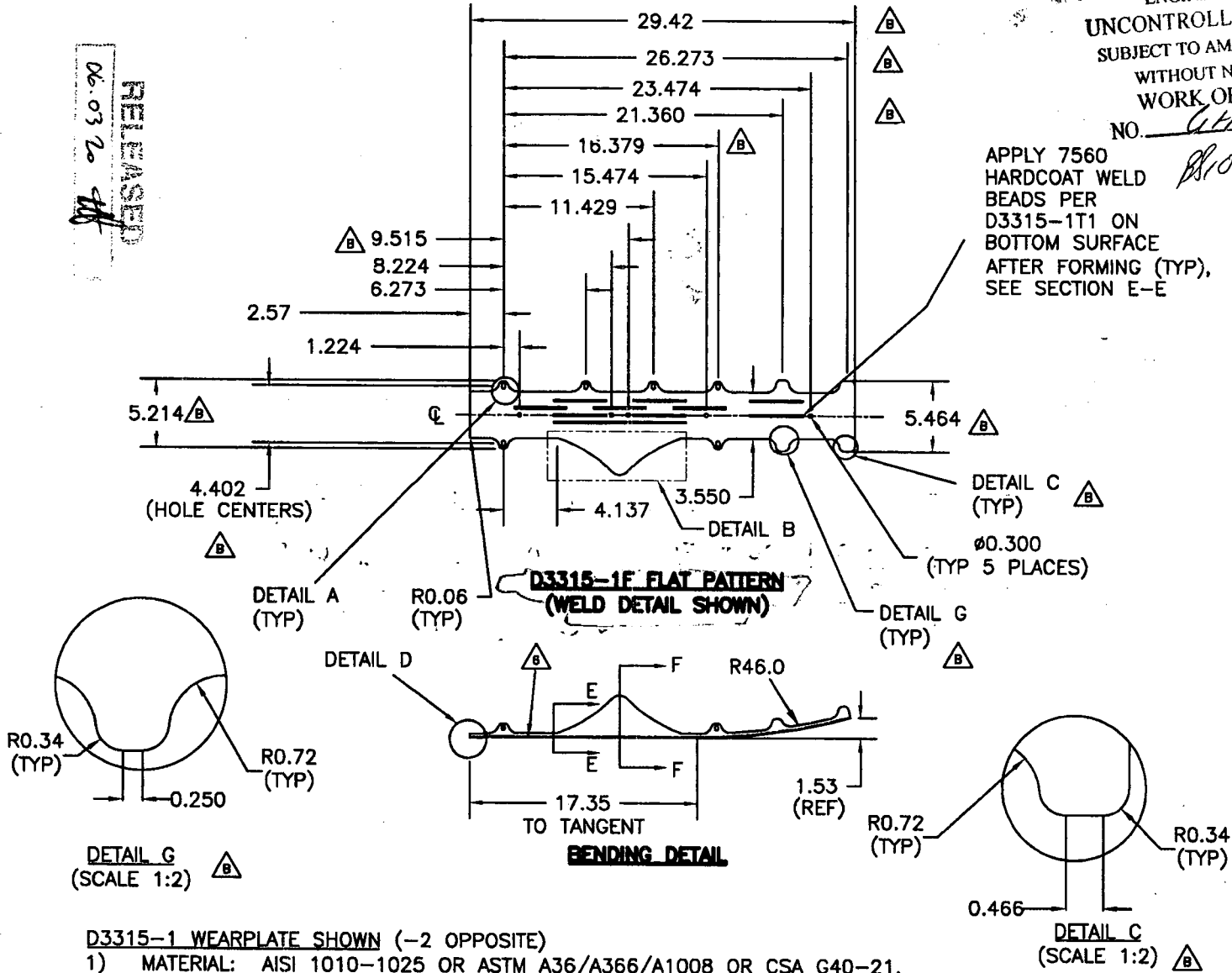
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 64548

APPLY 7560  
HARDCOAT WELD  
BEADS PER  
D3315-1T1 ON  
BOTTOM SURFACE  
AFTER FORMING (TYP),  
SEE SECTION E-E

**DART**

RELEASED  
06.03.20 *th*



**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
\*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	TITLE	SCALE
84	84	WEARPLATE	1:12
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>th</i>	<i>th</i>	D3315	SHEET 1 OF 4
DATE	DATE	DATE	DATE
06.01.31	04.09.10	06.01.31	
	NEW ISSUE	UPDATE DIMENSIONS	

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DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

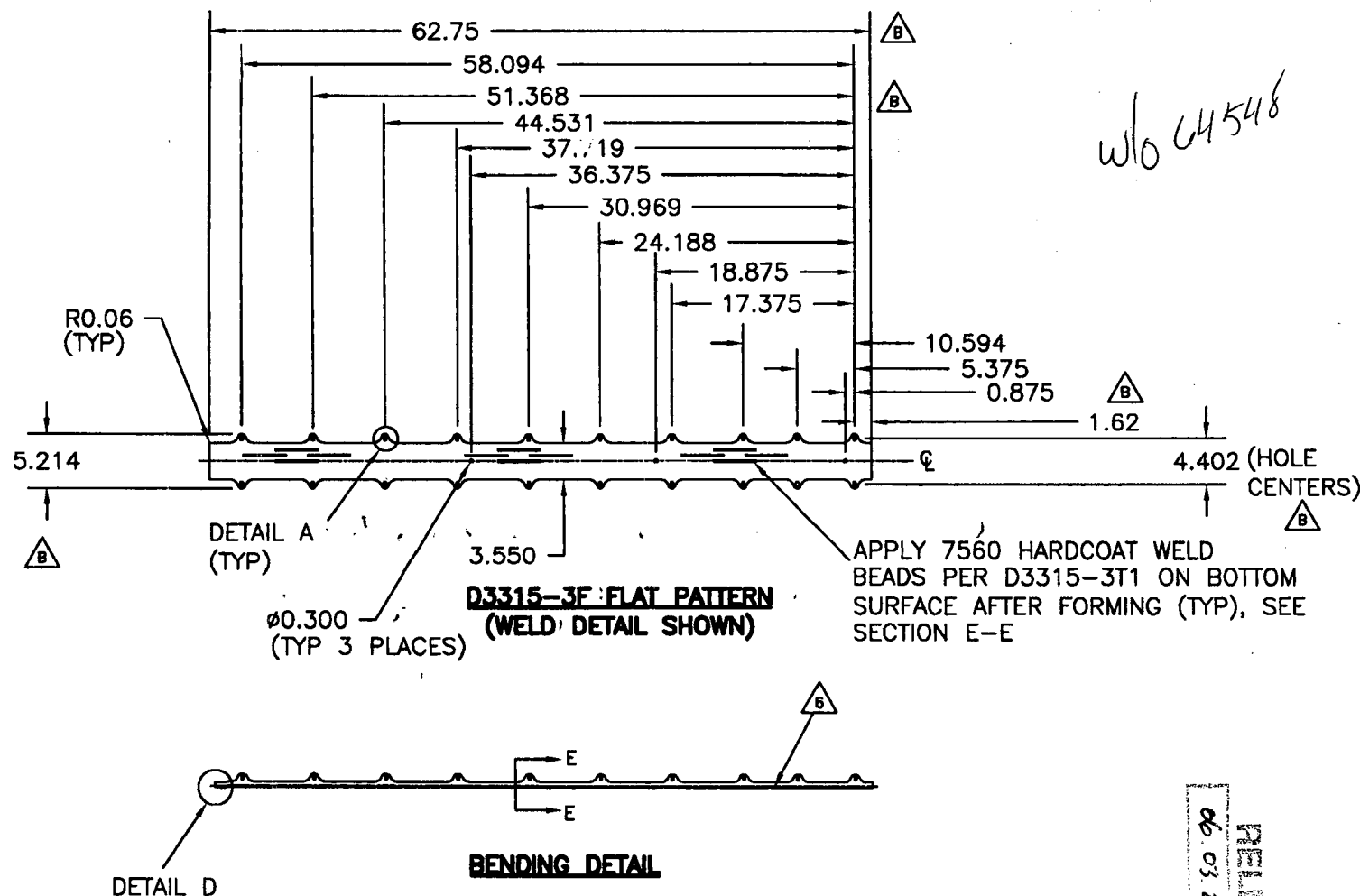
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DATE	06.01.31	DRAWING NO.	D3315		SHEET 2 OF 4
		TITLE	WEARPLATE		SCALE 1:16



**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

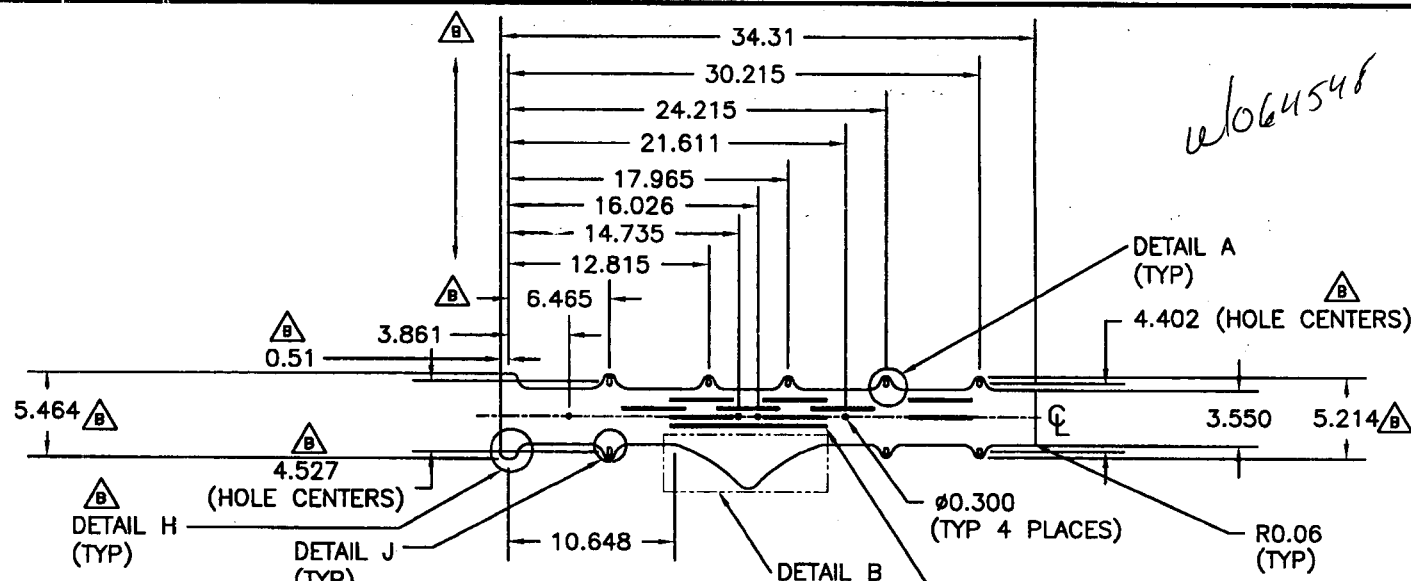
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

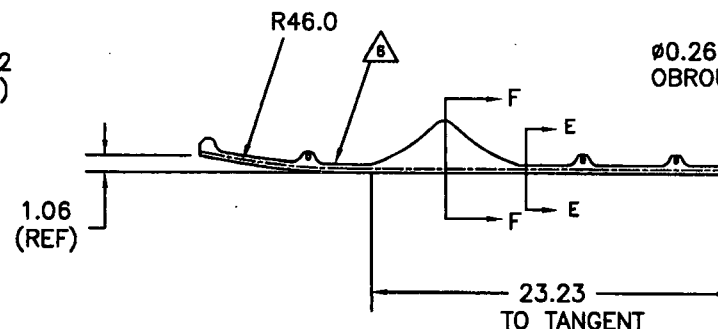
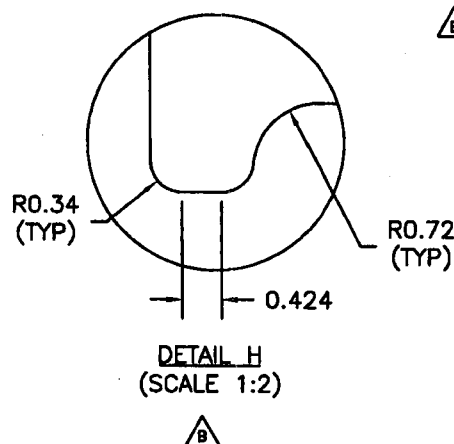
**DART**

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 3 OF 4
		SCALE	1:12	

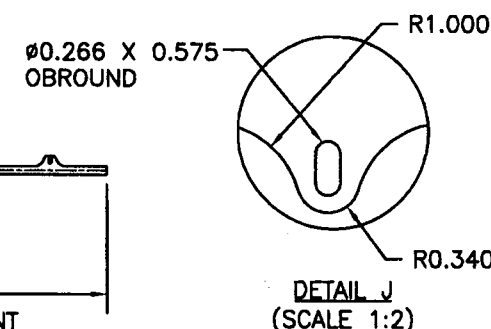


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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06 03 20  
RELEASED

u1064548

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

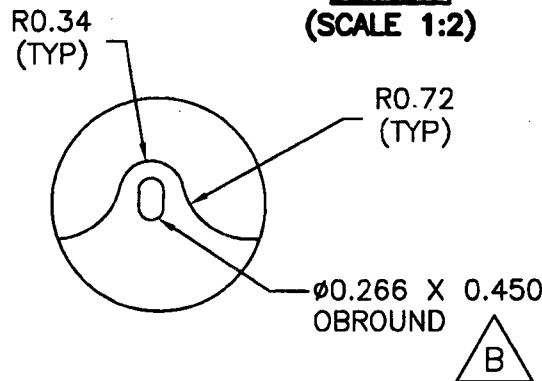
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**DART**

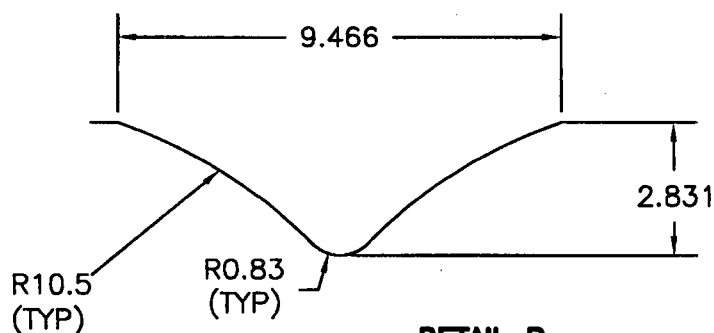
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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 4 OF 4
				SCALE
				NTS

u/o 64548

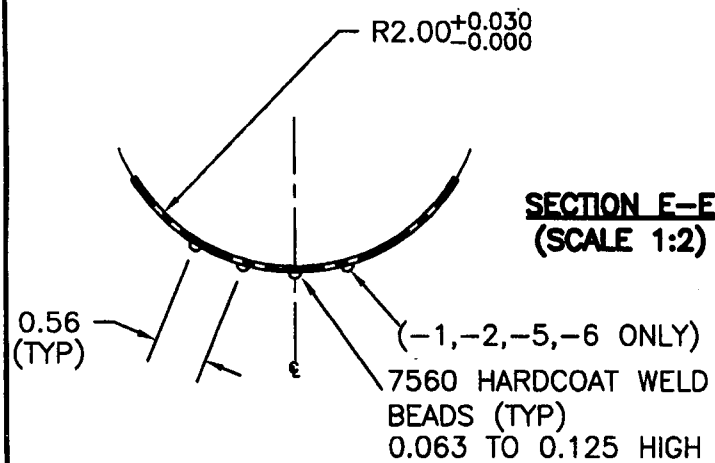
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(SCALE 1:2)



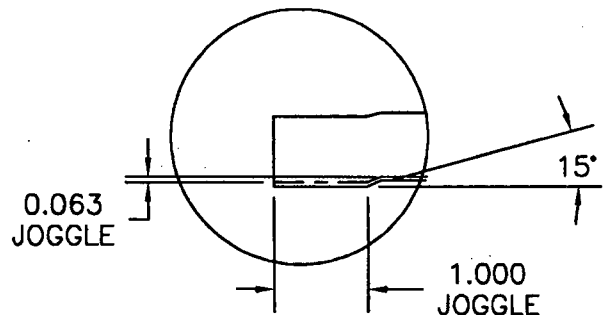
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(SCALE 1:4)



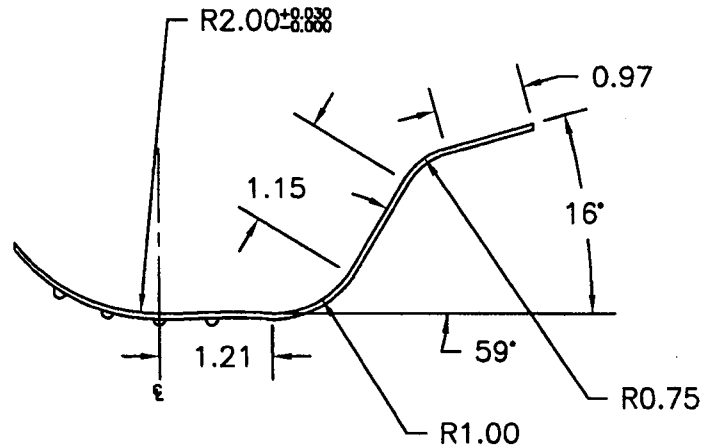
**SECTION E-E**  
(SCALE 1:2)



**DETAIL D**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)



06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries